

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021462**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12BE, weld No. DP3016-001-021. The welder is identified as #044504. ZPMC QC is identified as Mr.Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-4G(4F)-FCM-REPAIR-1.The weld repair report is WR20290. The welding variables were recorded at, Amperage 158, volts 22.6.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12BW to 12CW, weld No. OBW12C-001. The welder is identified as #046709. ZPMC QC is identified as Mr.Wang Zhu. The welding variables recorded by QC appear to comply with WPS-345-4G(4F)-FCM-REPAIR-1.The weld repair report is CWR2821R1. The welding variables were recorded at, Amperage 144, volts 23.7.The In-process SMAW appears to be progressing in compliance with approved contract documents.

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Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Side Plate for OBG segment 12BW at Crossbeam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3009-005

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Side Plate for OBG segment 12CW at Crossbeam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3011-001

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12BW at Crossbeam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3009-006

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12CW at Crossbeam side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3011-002

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified

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as corner joint joining between edge Plate to side Plate for OBG segment 12CW at Counter Weight side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3010-001

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Side Plate for OBG segment 12BW at Counter Weight side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA3008-005

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between edge Plate to edge Plate for OBG segment 12BW to 12CW at Crossbeam side. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBW12A-003

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
